

shy Jan. 31

Work Order ID 79381

79381

Page 1

Wednesday, January 25, 2012 11:48:32 AM

Item ID: D4434-047 Accept *N900040100* Setup Start *NS1*
 Revision ID: ~~PRELIM~~ Stop *NS2*
 Item Name: Cover Assembly
 Start Date: 1/25/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: AP Date: 1/20/25 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4434	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4434-7 as per Dwg								
6061.040	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

1B12-1-26

(2)

1B12-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		5/12/12		(42)			
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00		SB 12/01/12		(2)			
140 *140* Small Fab Small Fab	Transfer drill hole as per dwg Memo	0.00 0.00		FF 12-01-27		(2)			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		512/1/12		(F2)			
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2	BR	12-1-30	
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2X	Ø	M	12/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180									
Small Fab	Memo	0.00							
Small Fab	Install rivet as per dwg								
185	QC5- Inspect part completeness to step on W/O	0.00							
185									
QC	Memo	0.00							
Quality Control									
186	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
186									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:30 OVEN TEMPERATURE: 320°F FINISH TIME: 10:00								

Handwritten signature and date: 12/01/30 (2)

Handwritten circled number: 2

Handwritten text: 2x M-12/01/31

Handwritten text: M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 79381***79381***

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Required Date: 2/3/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
187	QC3- Inspect Part Finish	0.00							
187									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: <u>SHIP</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/1/31
12-5631

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Wednesday, January 25, 2012 11:48:36 AM

Work Order ID: 79381

79381

Parent Item: D4434-047

D4434-047

Parent Item Name: Cover Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA5 EC verified by:JLM IPP RevC 12.01.24
PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040		Purchased	No			100	sf	330.9100	0.5789	0.609368			
--------------	--	-----------	----	--	--	-----	----	----------	--------	----------	--	--	--

M6061T6S 040

6061-T6 .040 Sheet

**

B12-1-26

Location

Loc Qty

Loc Code

MAT021

330.91

113004

2.5

117653

40.91

120154

95.5

120218

192

MS20470AD4-3

Purchased

No

185

Each

5,950.000

2

2

MS20470AD4-3

Rivet - Universal Head

**

120218
12/01/30

Location

Loc Qty

Loc Code

Mezz

5950

1642

1316

2193

4634

4

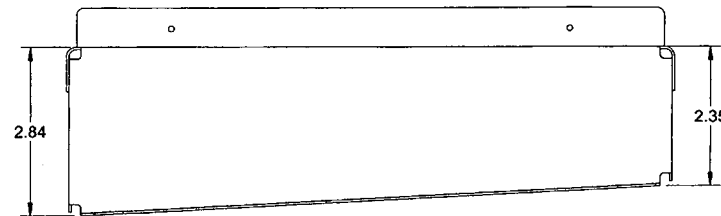
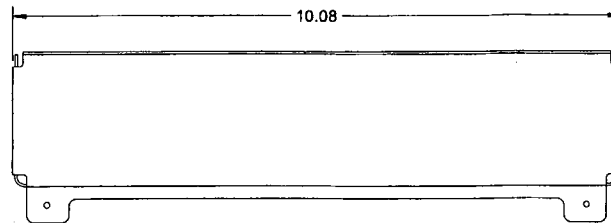
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

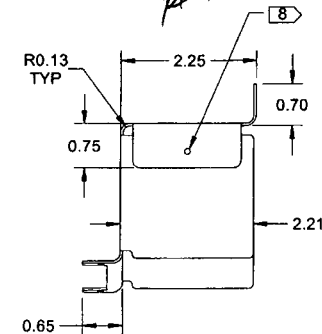
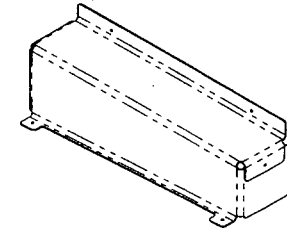
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ASSESSMENT
NO 79381
P/D 12-01-25



D4434-7 BRACKET

RELEASED
2012-01-23
MMA

NOTES:

- 1) MATERIAL: MAKE FROM D4434-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLE THRU 2 PLACES

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4434	SHEET 12 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

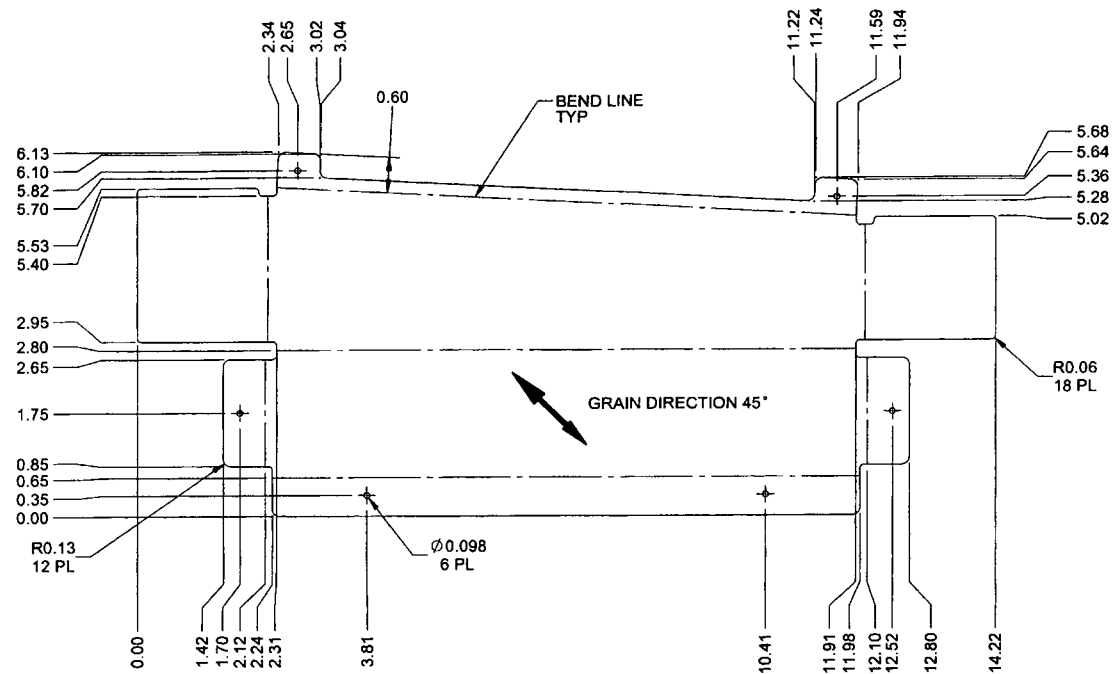
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NOTE: Date & initial all entries



D4434-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
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DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
DATE	12.01.17	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD		Work Order: 79381
Description: COVER ASSEMBLY		Part Number: D4434-47
Inspection Dwg: D4434-7		Rev: A
Page 1 of 1		

☒ First Article ☒ Prototype

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
---------	-----------	-----------	--------	--------	--------	----------------------	----------

Ø .008	1.42	± .004 - .001	1.41	2		V	Bc2
1.70	1.42	± .030	1.417	2		V	
2.24	1.70	± .030	1.691	2		V	
3.81	2.24	± .030	2.244	2		V	
10.41	3.81	± .030	3.807	2		V	
11.98	10.41	± .030	10.41	2		T	Bc1
12.52	11.98	± .030	11.98	2		T	
12.86	12.52	± .030	12.52	2		T	
14.22	12.86	± .030	12.86	2		T	
1.35	14.22	± .030	1.348	2		V	
1.85	1.35	± .030	1.852	2		V	
1.75	1.85	± .030	1.740	2		V	
2.65	1.75	± .030	2.644	2		V	
2.95	2.65	± .030	2.95	2		V	
5.53	2.95	± .030	5.53	2		V	
5.82	5.53	± .030	5.823	2		V	
6.13	5.82	± .030	6.13	2		V	
5.02	6.13	± .030	5.015	2		V	
5.36	5.02	± .030	5.363	2		V	
5.64	5.36	± .030	5.646	2		V	
2.34	5.64	± .030	2.336	2		V	
2.66	2.34	± .030	2.652	2		V	

Measured by: R	Date: 12-1-26
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Audited by: S	Date: 12/4/26
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Prototype Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

FIRST ARTICLE INSPECTION CHECKLIST

Work Order: 79381	Part Number: D4434-047	Description: COVER ASSEMBLY	Inspection Dwg: D4434-7	Rev: A
Page 1 of 1				

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.67	± .030	3.621	✓		V R&Q	
11.24	± .030	11.24	✓		T R&Q	
11.59	± .030	11.59	✓		T	
11.94	± .030	11.94	✓		T	
1.046	± .001	1.038	✓		V	

Measured by: B	Date: 12-1-76	Audited by: S	Date: 12/1/76	Prototype Approval:	Date:
Rev A	Date	Change	Revised by: KJULM	Approved	New Issue